

Work Order ID 113132

February-12-14 9:57:24 AM

113132

Page 1

Item ID: D2894-1

Revision ID:

Item Name: 2.75 Support

Start Date: 2/10/14

Start Qty: 10.00

10

Required Date: 2/10/14

Req'd Qty: 10.00

10

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLSDate: 14-02-13

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2894

E

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA253
Tumble & Deburr

0.00

0.00

100SL / 14-03-13

110

110

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

100SL / 14-03-13

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

D.A 14/03/14100DAG
08
2-83

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 113132

February-12-14 9:57:24 AM

113132

Page 2

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Revision ID:

Item Name: 2.75 Support

Start Date: 2/10/14

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Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
Description

130

Identify as per dwg & Stock Location: LG52***130***

Packaging

Memo

Packaging

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp10 0 0 AL
14-3-19

140

QC21- Final Inspection - Work Order Release

140

QC

Memo

Quality Control

0.00

0.00

PL 14-03-20

ML5 14-03-19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

February-12-14 8:38:59 AM

Page 1

Work Order ID: 113132

113132

Parent Item: D2894-1

D2894-1

Parent Item Name: 2.75 Support

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.11.26Added mask holeKJ
IPP Rev:C ECN 993 07-11-07 DD verified by:EC
IPP D 08.03.19 Re-format EC verified by DD
11.10.03 ASPER REV.C DD VERF:EC

IPP REV:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK079		Manufactured	No			100	Each	6.0000	0.5	5			

DSK079

D2894-1 Turning Detail

**

Location

Loc Qty

Loc Code

MAT060

6

*105473

3

94328

3

3
2

FR 14/03/07

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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DART AEROSPACE LTD		Work Order:	113132
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		466	466	466	466	462
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		063	063	063	063	063
AD	1.766	1.786		1.783	1.781	1.775	1.775	1.779
AE	0.020	0.040		040	040	030	030	030
AF	0.260	0.267		261	261	261	261	261
AG	0.170	0.190		180	180	180	180	180
AH	0.150	0.170		158	158	158	158	158
AI	1.970	2.030		1.997	1.995	1.998	1.998	2.000
AJ	0.240	0.260		250	250	250	250	250
AK	1.880	1.900		1.894	1.891	1.892	1.894	1.894
AL	0.500	0.505		501	501	502	502	502
AM	0.188	0.194		191	191	191	191	191
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				0.000	0.002	0.001	0.002	0.000

Measured by:	JL	Date:	14-3-12
Audited by:	B.A.	Date:	14/03/14
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	

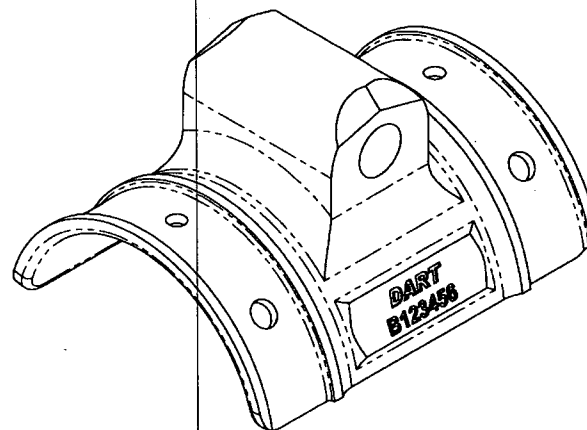
DART AEROSPACE LTD		Work Order: 113132
Description: Ø2.750 Support		Part Number: D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.454	0.474		.462	.463	.463	.460	.460
AB	3.062	3.082		3.072	3.072	3.072	3.072	3.072
AC	0.053	0.073		.063	.063	.063	.063	.063
AD	1.766	1.786		1.779	1.777	1.777	1.778	1.778
AE	0.020	0.040		.030	.030	.030	.035	.035
AF	0.260	0.267		.261	.261	.261	.261	.261
AG	0.170	0.190		.180	.180	.180	.180	.180
AH	0.150	0.170		.158	.158	.158	.158	.158
AI	1.970	2.030		2.003	1.998	1.998	1.999	1.999
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	1.880	1.900		1.891	1.892	1.893	1.888	1.890
AL	0.500	0.505		.502	.502	.502	.502	.502
AM	0.188	0.194		.191	.191	.191	.191	.191
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject				.0015	.001	.003	.0005	.001

Measured by: JH / MA 14-03-13	Date: 14-3-12
Audited by: H.A. DAS 08 08	Date: 14/03/14
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
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D2894-1 Ø2.750 SUPPORT

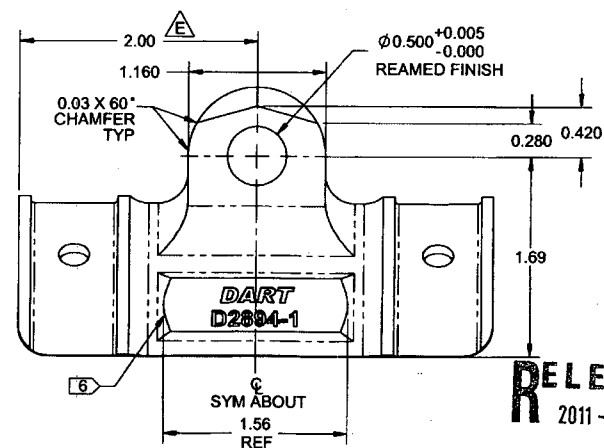
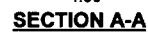
113132 MLD
1402-13

RELEASED
2011-09-29
JW

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
PER ASTM A564 OR AMS 5643 OR AISI 630
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C6-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2894	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	Ø2.750 SUPPORT	NTS
DATE	11.09.07	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2894-1 Ø2.750 SUPPORT

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2894	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	Ø2.750 SUPPORT	NTS
DATE	11.09.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	